

Work Order ID 86031

June-19-12 4:06:54 PM

86031 ALIKE

Page 1

Item ID: D3371-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Lock Assembly

Start Date: 19/06/2012 Start Qty: 4.00

~~*4*~~

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

~~*4*~~

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/06/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3371

Rev B

120

0.00

120

Small Fab

Small Fab

Small Fab

Memo

0.00

- 1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
- 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
- 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
- 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<u>M 120369</u>

130

0.00

130

Small Fab

Small Fab

Small Fab

Memo

0.00

- Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

SPB
12/07/04

③

3

SPB
12/07/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86031

June-19-12 4:06:54 PM

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Page 2

Item ID: D3371-041
Revision ID:
Item Name: Pedal Lock Assembly

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 19/06/2012 Start Qty: 4.00 ***4***
Required Date: 03/07/2012 Req'd Qty: 4.00 ***4***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Small Fab Small Fab	Small Fab Memo 1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4	0.00 0.00				(3)			2/12/07/04
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		512107/04 04208		(B)			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>SK491</u> Memo	0.00 0.00				3x			SP 12-7-4.

24207

W/O:		WORK ORDER CHANGES					
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Page 3

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N900040100Setup Start ***NS1***

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Item Name: Pedal Lock Assembly

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

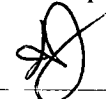
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/7/4 
MF
12-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 4:07:00 PM

Page 1

Work Order ID: 86031

86031

Parent Item: D3371-041

D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028		Purchased	No			120	Each	186.0000	2	8			
238-028													
3/16" Dowel Pin .5" long													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST400				186					
				106673				98					
				108114				61					
				17848				27					
AN526C832R6		Purchased	No			120	Each	282.0000	4	16			
AN526C832R6													
Screw													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST347				282					
				16612				282					
D2728-7		Manufactured	No			120	Each	0.0000	0	0			
D2728-7													
Dart Logo label													
D3371-1		Manufactured	No			120	Each	1.0000	1	4			
D3371-1													
Pedal Lock Base													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				-8					
				ST485				1					
				70040				1					
				ST490				8					

**

SA 12/07/04

**

SA 12/07/04

**

SA 12/07/07

**

SA 12/09/04

B 83515

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 86031

86031

Parent Item: D3371-041

D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3371-3 Manufactured No

120 Each 0.0000 1 4

D3371-3

Pedal Lock Cover

B 83516 ** 3 SB 12/02/04

D3373-7 Manufactured No

120 Each 20.0000 1 4

D3373-7

Cam Lock

** SB 12/02/04

Location

Loc Qty

Loc Code

ST039

20

B22160

80276

20

D3385-3 Manufactured No

120 Each 68.0000 1 4

D3385-3

Hinge

** SB 12/02/04

Location

Loc Qty

Loc Code

ST041

68

22387

68

CBL-1240 Purchased No

130 f 328.1417 1.6666 7.017263

CBL-1240

Cable

** SB 12/02/04

Location

Loc Qty

Loc Code

GA

328.141659

113565

3.911789

119021

311.19647

119690

13.0334

CBL-460 Purchased No

130 Each 668.0000 2 8

CBL-460

Loop Sleeve

** SB 12/02/04

Location

Loc Qty

Loc Code

GA

668

121574

668

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 86031

86031

Parent Item: D3371-041

D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3384-1 Manufactured No

130 Each 2.0000 1 4

D3384-1

Cyclic Sock

**

SB 12/07/04

Location

Loc Qty

Loc Code

ST486

2

D 85837 2

77011

2

1

AN960-416 NAS1149F0463P Purchased No

140 Each 0.0000 2 8

AN960-416

Washer

M 120739 **

6

SB 12/07/04

HX-81 Purchased No

140 Each 82.0000 1 4

HX-81

1/4"-20 SHCS 3/8" long

**

SB 12/07/04

Location

Loc Qty

Loc Code

ST

50

120357

50

ST390

32

114383

1

120773

31

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

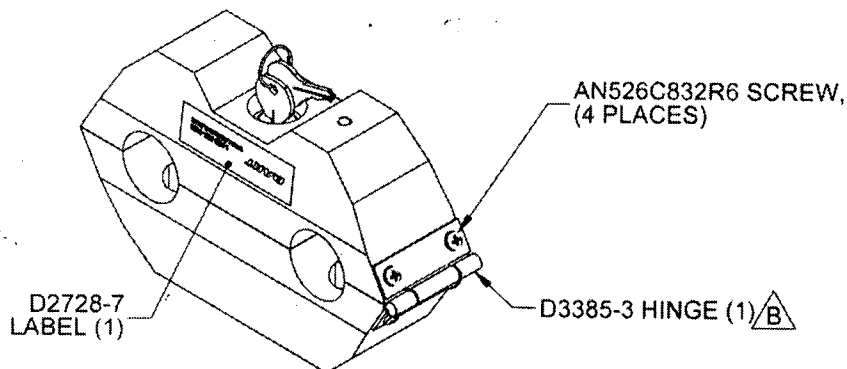
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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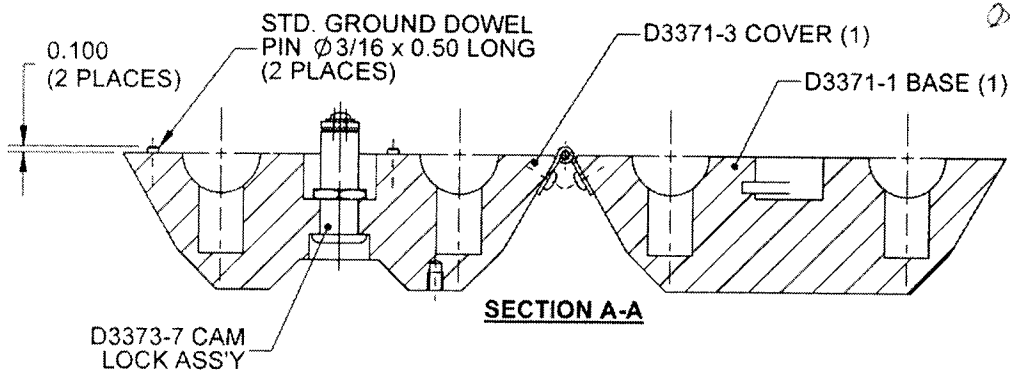


DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

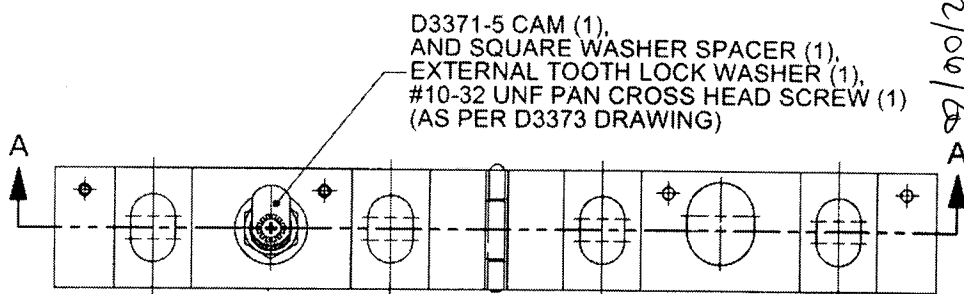


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
05/04/28



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86031 MJS
12/06/20

D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

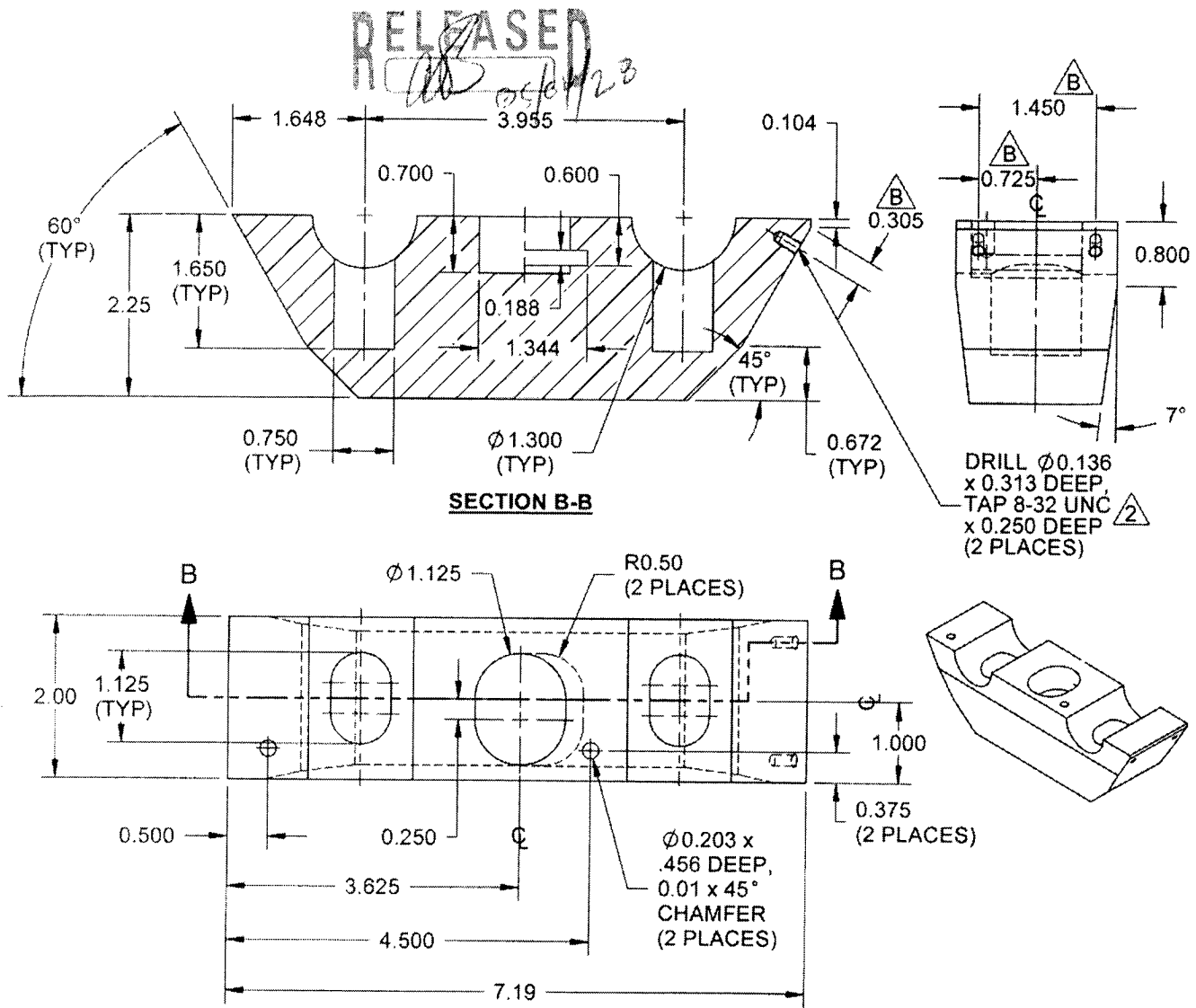
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 43	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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06031

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

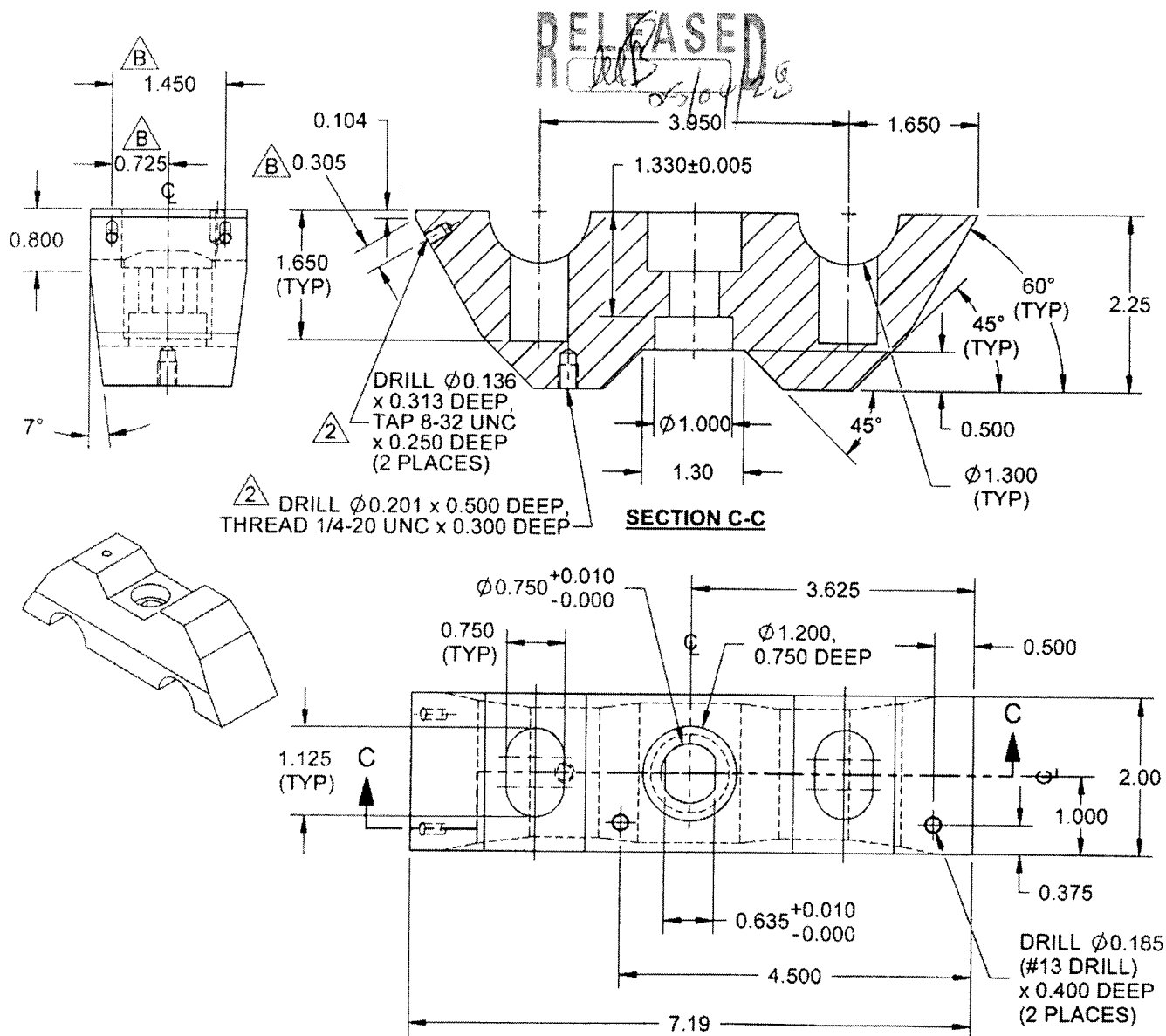
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
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Dart Aerospace Ltd

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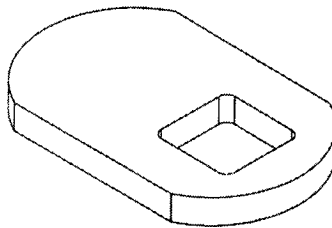
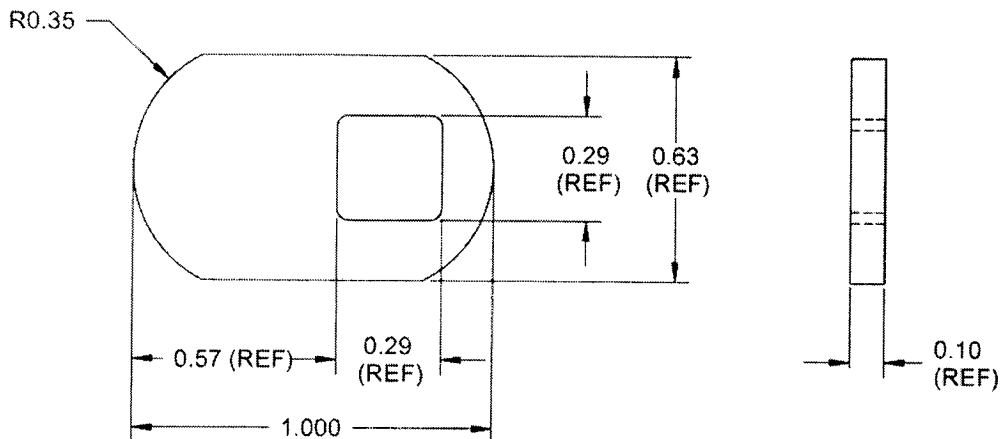
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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